

# Work Order ID 50592

July 16, 2009 11:37:47 AM



Page 1

Item ID: D2249-041

Accept



Setup Start



Revision ID: E

Item Name: Fitting Assembly

Stop



Start Date: 07/17/2009 Start Qty: 3.00



Cust Item ID:

Required Date: 07/20/2009 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: *mf*

Date: *09-07-16* Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2249	Rev E								

100



Large Fab

0.00

Large Fab

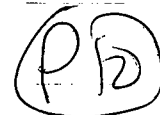
Memo

0.00

Large Fab

Weld as per Dwg D2249 and QSI 004

*EL 7-8-6*



110



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

*QC 09-08-12*

120



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

*=) 8/2/09/13*

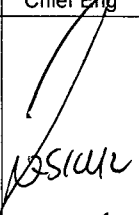

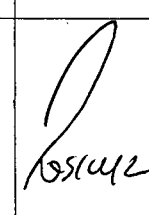
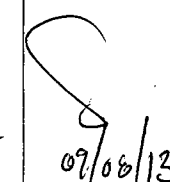
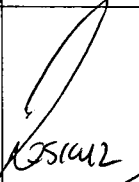

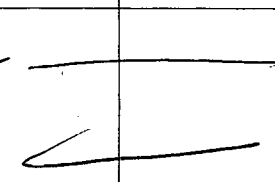
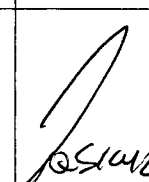
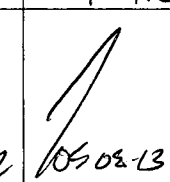


Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2249-041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>50592</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/8/13	#100	One welding assembly has been welded cracked. 0.800" dim is off with. RL part was welded cracked		Scrap and destroy qty 4 no Revoke	EL. 9-8-13			
		Lack of Attention (LOA.) Human error.						

NOTE: Date & initial all entries

# Work Order ID 50592

July 16, 2009 11:37:47 AM



Page 2

Item ID: D2249-041  
Revision ID: E  
Item Name: Fitting Assembly

Accept



Setup Start



Stop



Start Date: 07/17/2009 Start Qty: 3.00



Required Date: 07/20/2009 Req'd Qty: 3.00

Cust Item ID:

Customer:

Reference:

Run Start



Stop



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

Memo

M112260

0.00

START TIME:

12:40pm

OVEN TEMPERATURE:

FINISH TIME:

400°F

=? JJ 09-08-13 (X2)

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

u.m. 09 - 08 - 13 (2)

150



Packaging

Packaging

Identify as per dwg & Stock Location: S11

0.00

Memo

0.00

(X2) MO 09/08/17

# Work Order ID 50592

July 16, 2009 11:37:47 AM



Page 3

Item ID: D2249-041

Accept



Setup Start



Revision ID: E

Item Name: Fitting Assembly

Stop



Start Date: 07/17/2009 Start Qty: 3.00



Cust Item ID:

Required Date: 07/20/2009 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/08/19 *[Signature]*

MF 09-08-19

# Picklist Print

July 16, 2009 11:37:47 AM

Page 1

Work Order ID: 50592

Parent Item: D2249-041RevE

Parent Item Name: Fitting Assembly


Comments:

Start Date: 07/17/2009


Required Date: 07/20/2009

Start Qty: 3.00


Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2249-1RevE		Manufactured	No			100	Each	6.0000	6.0000			
												
Lug												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	6	
40893	6	

D2249-3RevE		Manufactured	No			100	Each	33.0000	3.0000			
												
Base Plate												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	33	
34671	21	
40893 A	12	

D2249-5RevE		Manufactured	No			100	Each	29.0000	6.0000			
												
Gusset												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	17	
46322	17	
Main Warehouse		
WA	12	
50237	12	

CPL 09-08-05

CPL 09-08-05

CPL 09-08-05

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

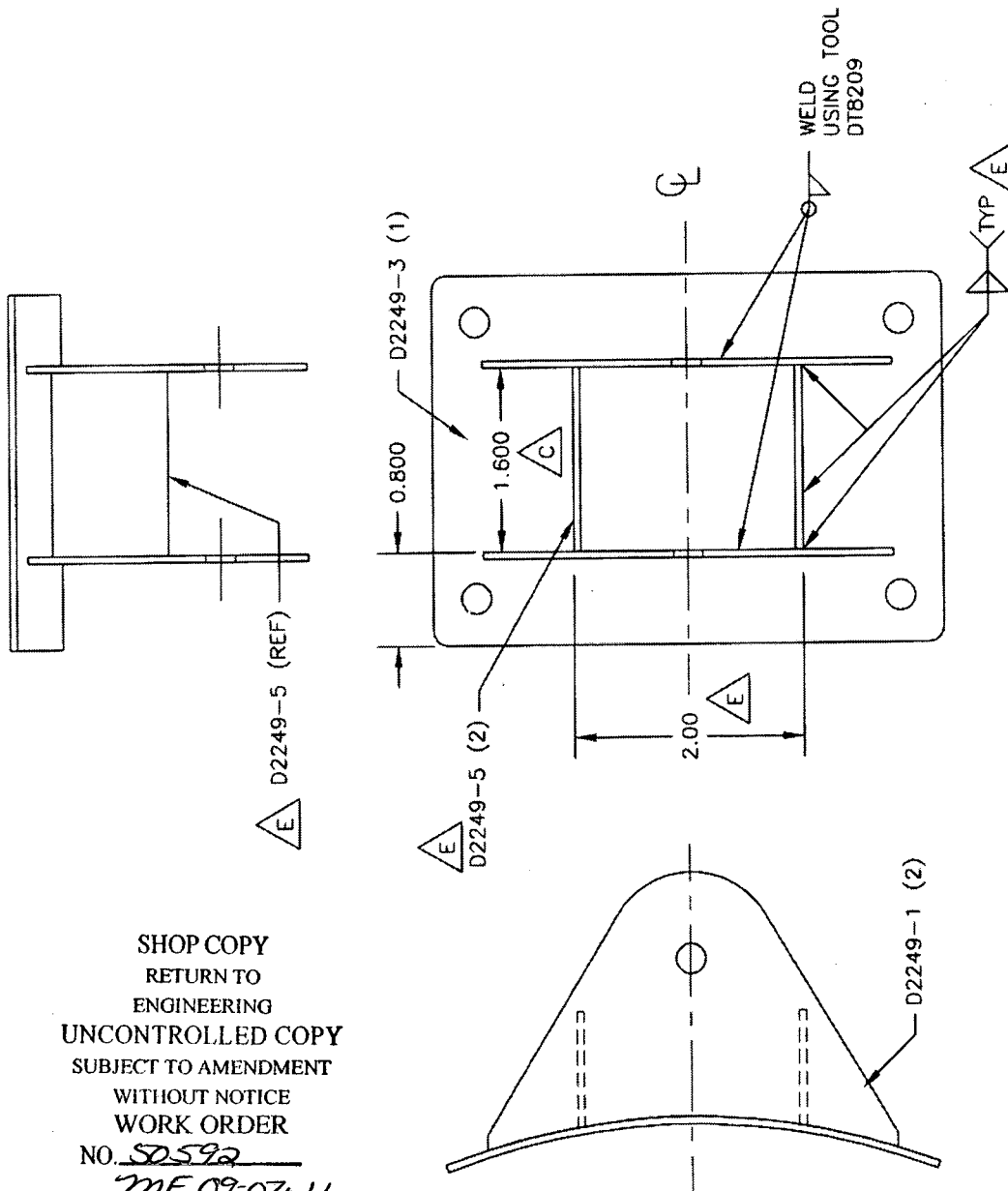
**NOTE:** Date & initial all entries

**DART**



RELEASED  
99.10.12 KE

DESIGN KE	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED [Signature]	DRAWING NO. D2249	REV. E SHEET 1 OF 4
DATE 99.09.20		TITLE FITTING	SCALE NTS
A	94.06.20	NEW ISSUE	
B	95.11.30	DIMENSION CHANGE	
C	95.12.14	DIMENSION CHANGE	
D	98.04.30	Ø0.261 WAS Ø0.257 (TSR A179) REMOVED DUPLICATE DIMENSIONS	
E	99.09.20	ADDED GUSSET	



D2249-041 ASSEMBLY

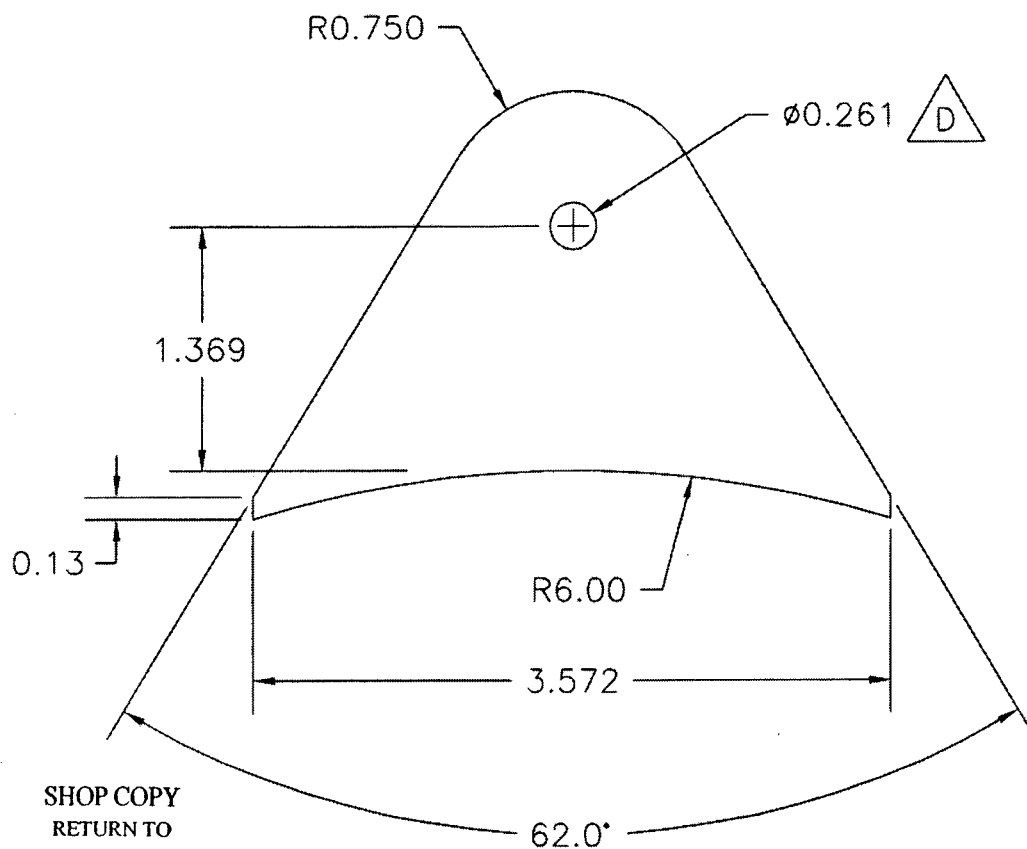
MATERIAL: AISI 304/316 SS, 0.063 THICK  
WELD PER DART QSI 004  
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
ALL DIMENSIONS ARE IN INCHES  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 50592  
MF 09-07-16



DESIGN <b>KE</b>	DRAWN BY <b>RF</b>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>KE</b>	APPROVED <b>[Signature]</b>	DRAWING NO. D2249	REV. E SHEET 2 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

RELEASED  
19.10.12 KE



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 50592  
MF 09-07-16

D2249-1 LUG

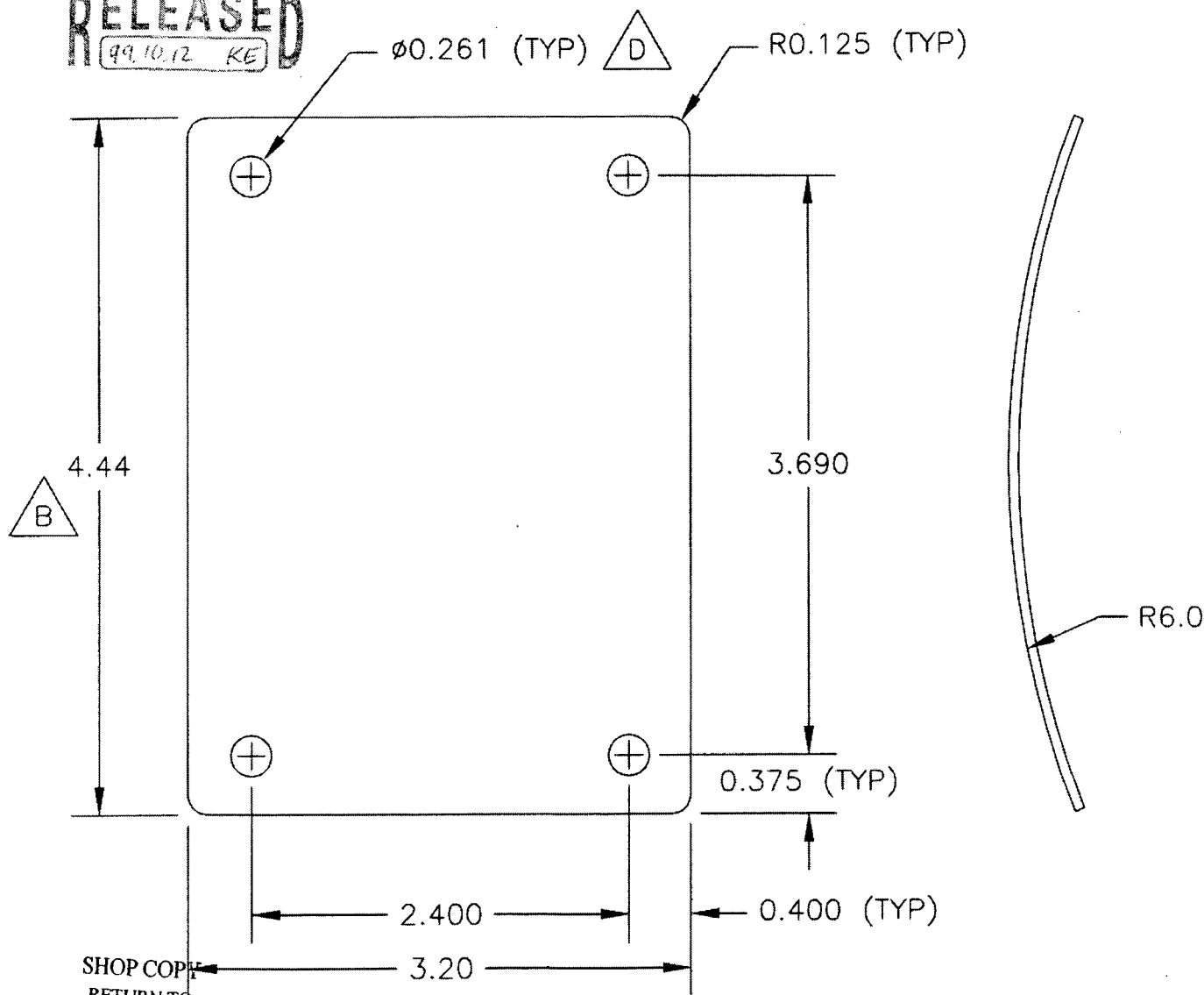
MATERIAL: AISI 304/316 SS 0.063 THICK  
ALL DIMENSIONS ARE IN INCHES  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED





DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2249	REV. E SHEET 3 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

RELEASED  
99.10.12 KE



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30592  
MF 09-07-16

FLAT PATTERN

BEND DETAIL

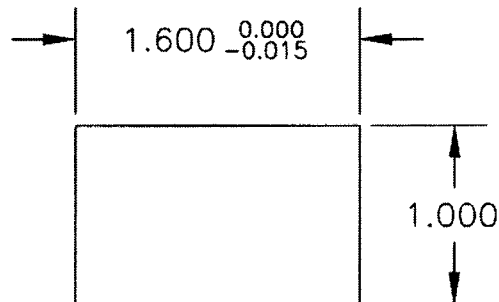
D2249-3 BASE PLATE

MATERIAL: AISI 304/316 SS 0.063 THICK  
ALL DIMENSIONS ARE IN INCHES  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>RF</i>	DRAWING NO. D2249	REV. E SHEET 4 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

RELEASED  
99.10.12 *KE*



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 50592  
*MF 09-07-16*

D2249-5 GUSSET

MATERIAL: AISI 304/316 SS 0.063 THICK  
ALL DIMENSIONS ARE IN INCHES  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED